

Work Order ID 85916

June-18-12 2:31:24 PM

85916

Page 1

Item ID: D4084-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 18/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4084	<u>B A 11/12-06-19</u>								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA960 FOLIO REV: <u>11</u> DWG REV: <u>A</u> 2-Deburr any rough edges								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

mk 12/08/20
B.A 12/08/21

mk 12/08/20
B.A 12/08/21

24 12-8-21

6 φ

6 φ

6 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85916

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 18/06/2012 **Start Qty:** 6.00

6

Customer:

Required Date: 02/07/2012 **Req'd Qty:** 6.00

6

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 92

0.00

170

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Work Order ID 85916***85916***

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Accept

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Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 18/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCS 12/08/23

MF
12-08-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 85916

85916

Parent Item: D4084-1

D4084-1

Parent Item Name: Maintenance Step

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-09-16 JLM VERIFIED BY:DD IPP
Rev:A 11.02.07 remove powdercoat per dwg DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No				Each	110.0000		6			

D6101-003

Saddle Billet, 7075

**

Location	Loc Qty	Loc Code
MAT040	66	
73775	2	
73780	7	
78599	10	
80765	0	
85434	40	
MAT042	43	
→ 81924	50	
MAT044	1	
73769	1	

6 and 12/08/20

W/O:		WORK ORDER CHANGES					
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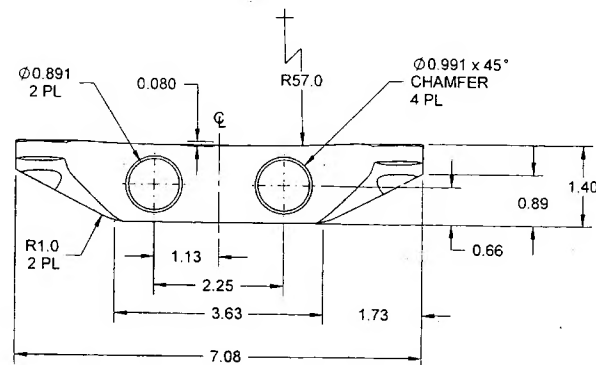
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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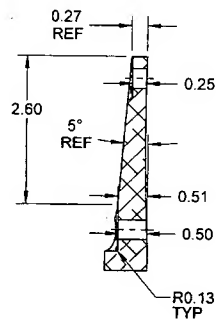
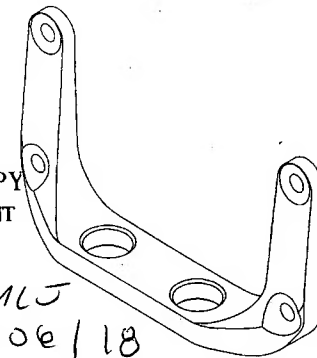
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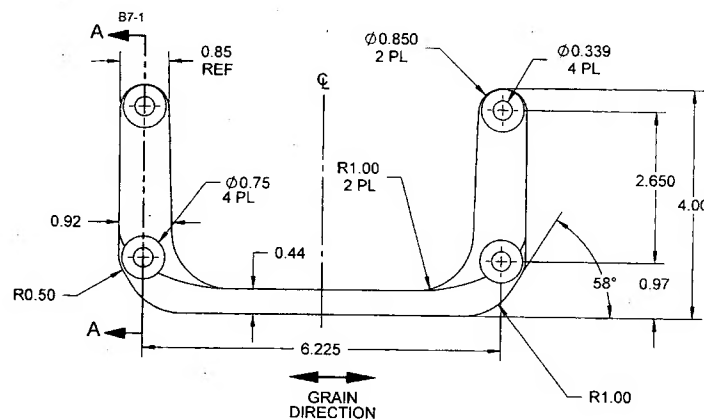


SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

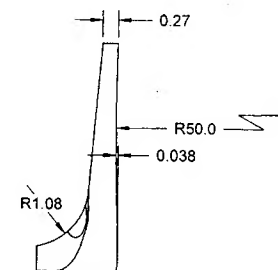
NO. 85916 MLJ
12/06/18



SECTION A-A C6-1



GRAIN
DIRECTION



RELEASED
2010-09-07

D4084-1 MAINTENANCE STEP

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM SHEET
PER QQ-A-250/12
MAKE FROM D6101-003 BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4084-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.53 lbs

A		NEW ISSUE		RF		10.04.12	
REV.		DESCRIPTION		BY		DATE	
DESIGN		RF		DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN		RF					
CHECKED		RF		DRAWING NO.		REV. A	
MFG. APPR.		RF		D4084		SHEET 1 OF 1	
APPROVED		RF		TITLE		SCALE	
DE APPR.		RF		MAINTENANCE STEP		NTS	
DATE		10.04.12		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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From: Roberto Fuentes <rfuentes@dartaero.com>
Sent: Tuesday, June 12, 2012 2:30 PM
To: Jean-Luc Menard ; David Shepherd
Cc: Mike Petsche
Subject: D4084 Rev. B

Hi JL,

You brought to my attention D4084 Rev. B on Section A-A the R0.13 typ is too big for washer, my model have R0.031 and also you Surfcam model. Therefore it must be a typo in the drawing. Please advise engineering to correct the drawing please.

Thanks,
Roberto